Work Ord Friday, Februar				*97	347*					YU/2	170	Page 1		
Item ID: Revision ID: Item Name:	D3876-3 Protector - F	wd Wall	,	Accept	*N9	*N900040100*						*NS1* *NS2*		
		Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*				D:				ı u.			
Approvals:	Process Pl QC:	lan: MVF	Date: 13-2-19 Date:	Tooling: SPC (Y/N):		Da Da			R	kun Start Stop		R1* R2*		
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours		I ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp.		
Draw Nbr	Re	evision Nbr											-	
D3876	Α													
*100 *100* Waterjet FLOW CNC Water	rjet	FLOW WATER JET Memo 1-Cut as per Deburr if ne	r Dwg D3876Dwg Rev:	0.00 0.00 Prog Re	2-				6_	0		JM13-2	-20	
110 *440*		QC2- Inspect parts off m	nachine FAI/FAIB	0.00										
110 QC Quality Control		Memo		0.00					6			JMB	-2 - 2€	
¹²⁰ *12∩*		QC8- Inspect parts - seco	ond check	0.00	\ 5				6					
QC Quality Control		Memo		0.00) J J				6	 .				

									•		DQA:	Date:			
NCR:	Yes	/ No				WORK ORDER NON-	100	NFORM	ANCE / UPI	DATE		<u> </u>			
		•							•		QA Closed:	Date:			
Mante Ond						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS			
Work Ord	er:	· · · · · · · · · · · · · · · · · · ·				Rework	7		Skid tubo	Crosstubo	1	Water Jet	Engineering		
Down No.				Scrap		I	Skid-tube Crosstube Machining Small Fab			d. Eng. Coor.	Quality				
Part No			 	Use-as-is	1		Thermoforming Finishing			re/Packaging	Other				
NCR I	No.					Work Order Update	-		Large Fab	Composite	1100,310	Supplier			
NCR NO.					TOTAL START SPARES						- 3/1-1-1-1	l ——I			
Root			Description of work ord		ption of work order update	Initial Action			tion	Sign &					
Cause		Date	Step	Qty	(or Non-conformance	Cr	nief Eng	Desci	ription	Date	Verification	QC Inspector		
Doc/Data							I		<u> </u>						
Equip/Tooling		i		:								,			
Operator									}						
Material									İ						
Setup	L														
Other															
Process															
Supplier															
Training															
Unapproved									<u> </u>		<u> </u>				
							AUI	LT CATE	GORY						
Land	ing (1				General	_	ר		_	· ¬		1		
	<u> </u>	Bending			<u> </u>	Bend		Grain		_	Ovalized		Pressure/Forced		
		Centre No	ot Concer	ntric to	o/s	BOM/Route	L	Hardwa			Over/Under	-	Temperature/Cure		
		Cracks				Broken/Damaged	\perp	-1	ion Incomplete	<u> </u>	Part Incorre		Weld		
	<u></u>	Crushed/	Crimped.		L	Burrs	_	-	ions Incomplete/l	Unclear	Part Lost/M	issing	Wrong Stock Pulled		
		Cuffs				Contamination		Mainte		<u> </u>	Part Moved				
		Heat Trea	it			Countersink		Mislabe	led	<u> </u>	Positioned \		٦		
1	1	Inspection Strip in Tube				Cut Too Short	-	Misread	t		Power Loss,	Surge Other			

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Drill Holes

Drawing

Finish Folio

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 97347 *97347* Friday, February 15, 2013 2:23:24 PM Item ID: D3876-3 Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: Protector - Fwd Wall **Start Date:** 2/15/2013 Start Qty: 6.00 Cust Item ID: Required Date: 2/22/2013 Req'd Qty: 6.00 **Customer:** Reference: Run Start Approvals: **Process Plan:** Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool # Set Up/ Tool ID Plan Reject Reject Accept Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 130 Identify as per dwg & Stock Location: 0.00 *130* Packaging 0.00 Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140 QC

Quality Control

Memo

0.00

MF 3-2-25

Insp.

Page 2

											DQA:	Date:	<i>*</i>
NCR:	Yes /	No				WORK ORDER NON-C	O	NFORM	MANCE / UPDA	ATE	•		
											QA Closed:	Date:	
Work Orde	~~.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orde	er					Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part I	Nο					Scrap	1	i	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
1 41(1	•••					Use-as-is	1		noforming	Finishing		re/Packaging	Other
NCR I	No.					Work Order Update	Large Fab Composite		,	Supplier			
							•				'		
Root					1	ption of work order update	1	nitial	Actio		Sign &		
Cause	D	ate	Step	Qty	(or Non-conformance	Ch	ief Eng	Descrip	tion	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling	Ш		:										1
Operator													
Material	Ш						ļ						
Setup	Ц												
Other	Щ						ł						}
Process													
Supplier	Ш												
Training	Ш												
Unapproved										_			
						· · · · · · · · · · · · · · · · · · ·	AUL	T CATE	GORY				
Landi					_	General		1			1		.
	-	_			<u> </u>	Bend	<u> </u>	Grain		<u> </u>	Ovalized	<u> </u>	Pressure/Forced
	—		t Concer	ntric to	o/s	BOM/Route	<u> </u>	Hardwa		ļ	Over/Under		Temperature/Cure
					<u> </u>	Broken/Damaged	<u></u>	4 '	ion Incomplete		Part Incorre	<u> </u>	Weld
			rimped.		_	Burrs	<u></u>	1	tions Incomplete/Un		Part Lost/M	issing	Wrong Stock Pulled
	\vdash					Contamination		Mainte			Part Moved		
	perator aterial tup ther cocess upplier taining				Countersink		Mislabe	eled		Positioned V	Vrong		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

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Friday, February 15, 2013 2:23:24 PM

Work Order ID:

97347

Parent Item:

D3876-3

Parent Item Name:

Protector - Fwd Wall

Start Date: 2/15/2013

Required Date: 2/22/2013

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A 09-01-14 new issue DD verifyed by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04 GE PLASTICS LEXAN SI	HEET	Purchased	No			100	sf	0.0000	3.86	24.378947 25	5		_ /MB-2-20

124655

124655

										DQA:	Date:	•
NCR:	es / No				WORK ORDER NON-C	O	VFORI	MANCE / UPD	DATE			
					·					QA Closed:	Date:	
Work Orde	ar:				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
WOIK OIGE					Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	No.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
		· · · · <u>-</u> ·			Use-as-is	1	l .	noforming	Finishing		e/Packaging	Other
NCR N	No.				Work Order Update	1		Large Fab	Composite		Supplier	
Root		Description of work order update		1	nitial	Act		Sign &				
Cause	Date	Step	Qty	•	or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC inspector
Doc/Data												
Equip/Tooling			ł									
Operator		1				Ì						
Material												
Setup												
Other												
Process			İ	ł								
Supplier												
Training												
Unapproved	<u> </u>	1	<u> </u>	<u> </u>		<u> </u>	T 64 T 6					
						AUL	T CATE	GORY				
Landi					General		la .			1	_] ₀ /5
					Bend	<u> </u>	Grain		ļ	Ovalized		Pressure/Forced
	⊢	lot Conce	ntric to	o/s	BOM/Route	-	Hardwa			Over/Under	 	Temperature/Cure
	 -			<u> </u>	Broken/Damaged	-	4 '	ion Incomplete	<u> </u>	Part Incorre		Weld
Cause Date Step Qty Doc/Data Equip/Tooling Departor Material Setup Other Process Supplier Fraining			Burrs	-	4	tions Incomplete/U	inclear	Part Lost/M	issing	Wrong Stock Pulled		
	⊢			<u> </u>	Contamination	-	Mainte		<u> </u>	Part Moved	Mana	
	Heat Tre	at			Countersink	1	Mislabe	eled		Positioned V	vrong	

Misread

Out of Calibration

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Drawing

Finish Folio

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DART AEROSPACE LTD	Work Order:	9734-7
Description: Protector – Fwd Wall	Part Number:	D3876-3
Inspection Dwg: D3876 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

		ı		<u> </u>		1
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.43	+/-0.030	3.43"	_		V	ThrmoI
11.05	+/-0.030	11.05	_		V	Produtor
18.69	+/-0.030	18.69"	-		+	Jenos
25.86	+/-0.030	25.86"	-		Т	
25.34	+/-0.030	25.34"	-		T	
21.86	+/-0.030	21.864	-		T	·• 1
7.84	+/-0.030	7.84"	-		٧	. 400
5.40	+/-0.030	5.40"	-		V	***
4.15	+/-0.030	4,15	-		V	
0.35	+/-0.030	0.35			V	
0.125	+/-0.010	0.126"	-	·	V	
1.84	+/-0.030	1.84"	ı		V	
<u> </u>			SAS			

Measured by:JmAudited by:15Prototype Approval:N/ADate:13-2-20Date:\$\int_{200}^{100}\$ \int_{200}^{100}\$Date:\$\int_{200}^{100}\$

Rev	Date	Change	Revis	sed b	У	Appr	oved
Α	09.06.22	New Issue	KJ	AS.	-	ZA	

